

Date: Friday, 11/17/2006 9:08:34 AM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE WELDMENT
Job Number	: 29522		
Estimate Number	: 12064		
P.O. Number	: <i>N/A</i>	Part Number	: D3355045
This Issue	: 11/17/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3355 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 26925	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 12/10/2006 Qty: 4 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: est rev A 06.01.20 new issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33551	handle tip
-----	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pick:

✓	qty	part number	description	batch	
	1	D3355-1	handle tip	<i>B29525</i>	<i>Cpl 06.12.19</i>

(4)

2.0	D33553	LARGE TUBING
-----	--------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pick:

✓	qty	part number	description	batch	
	1	D3355-3	large tubing	<i>B26942</i>	<i>Cpl 06.12.19</i>

(4)

3.0	238042	pin
-----	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

pin

Batch: ~~*M10117*~~ *M10684* *M101305*

*Cpl 06.12.19*

(4)

4.0	VA7130	spring plunger
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pick:

✓	qty	part number	description	batch	
	1	VA-7130	spring plunger	<i>M101251</i>	<i>Cpl 06.12.19</i>

(4)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: 27 Date: 07/01/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 11/17/2006 9:08:35 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 29522

Part Number: D3355045

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Cpl 06-12-19 (4)



Comment: Weld assembly as per dwg

6.0

QC5/9

WELD INSPECTION

M 06/12/19 (4)

7.0

POWDER COATING

POWDER COATING



M 18052



(4)

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

M 07/01/02

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

M 07 01 02

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Install spring plunger per dwg D3355

Cpl 07-01-03 (4)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5107

PB 07/01/03 (4)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

M 07.01.04

Job Completion



C 207101104

QCS Inspect work to current step.

M 07/01/03 (4)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-01-03	9.0	Add QC 5 after spring installation. Perm-Change		07-01-03		05/04/2	07-01-03

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

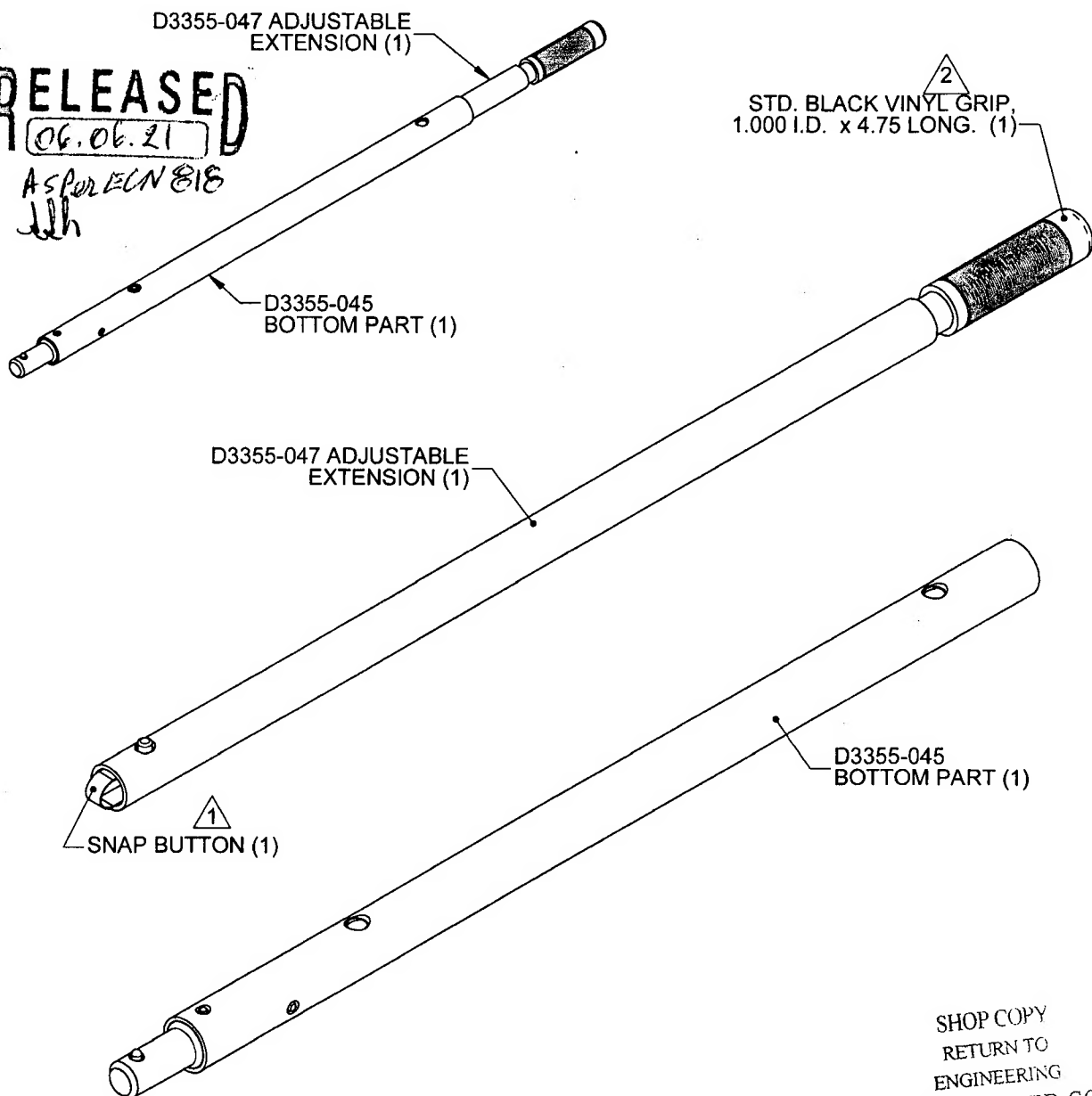
**NOTE:** Date & initial all entries



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DATE 06.05.31		TITLE HANDLE WELDMENT	SCALE 1:8
A	05.02.07	NEW ISSUE	
B	06.05.31	EDITED NOTE 1 (SHEET 2), UPDATE DETAIL B	

RELEASED  
06.06.21

AS PER ECN 818  
*[Signature]*



**D3355-041 HANDLE ASSEMBLY**

**NOTES:**

- 1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
- 2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

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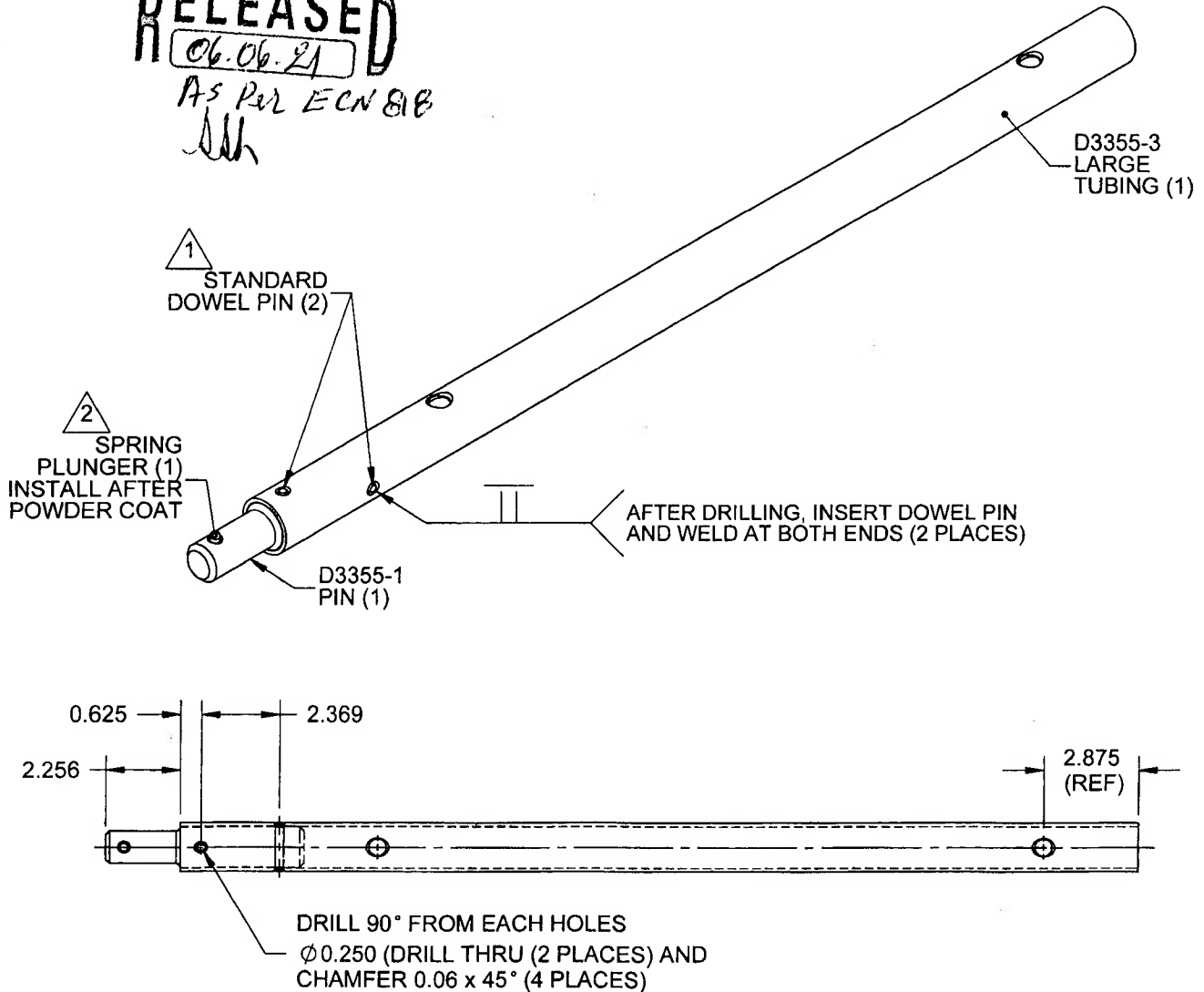


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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:5

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**06.06.21**

AS PER ECN 818

*[Signature]*



### **D3355-045 BOTTOM PART**

#### **NOTES:**

- 1) STEEL STANDARD GROUND DOWEL PIN,  $\varnothing 0.250 \times 1.50$  LONG  
POSSIBLE SUPPLIER: SPAENAU, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-17130
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

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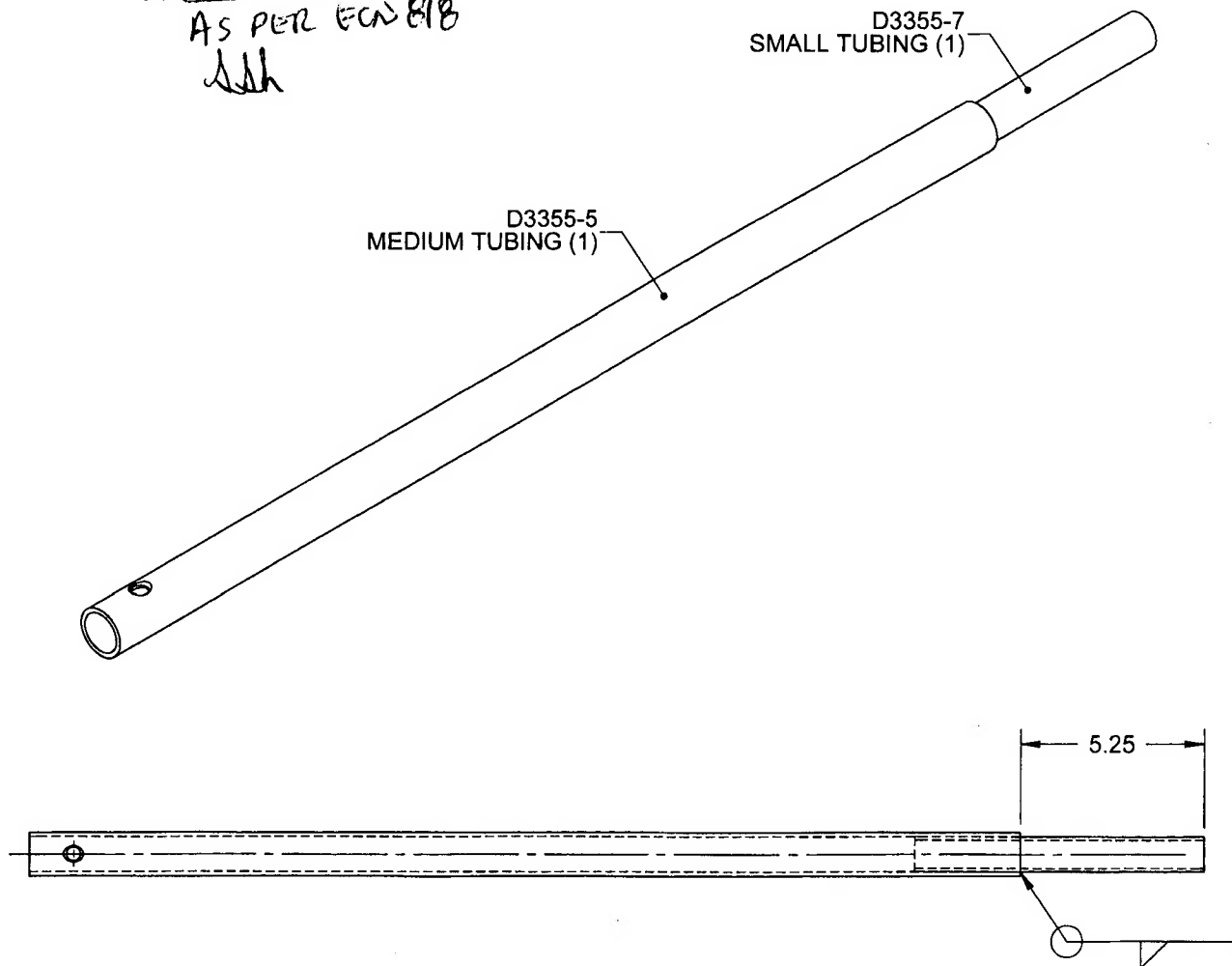


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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:5

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### D3355-047 ADJUSTABLE EXTENSION

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005.4.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

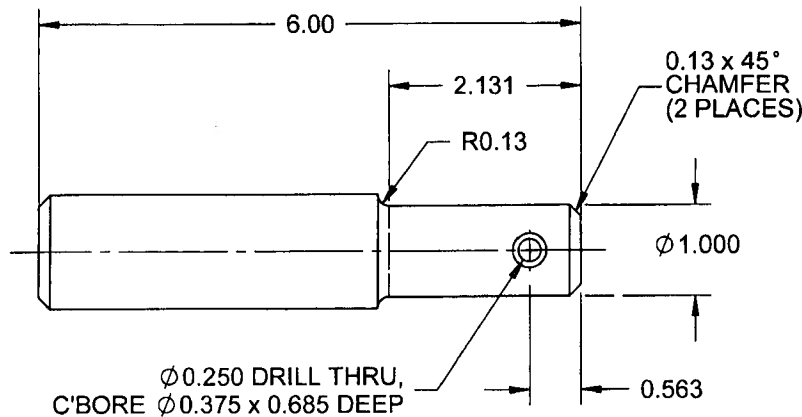
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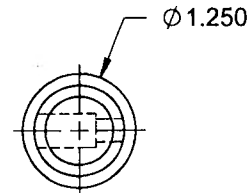
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:2



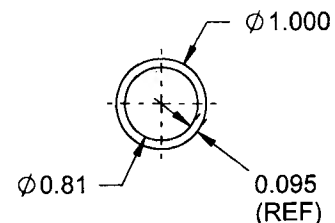
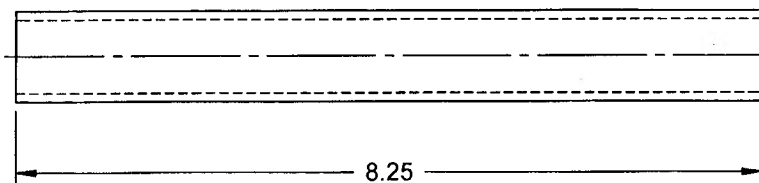
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*06.06.21*  
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### **D3355-1 PIN**

#### **D3355-1 NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020



### **D3355-7 SMALL TUBING**

#### **D3355-7 NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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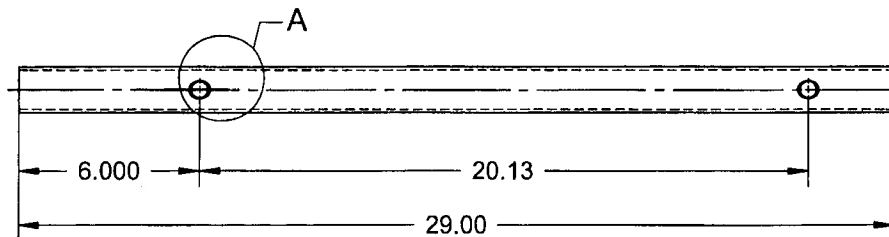
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:6

CHAMFER  $\phi 0.687$  (11/16)  
x 45°, 0.060 DEEP  
(2 PLACES)

$\phi 0.531$  (17/32) DRILL  
THRU (2 PLACES)

**DETAIL A**  
SCALE 1 : 2



### D3355-3 LARGE TUBING

#### NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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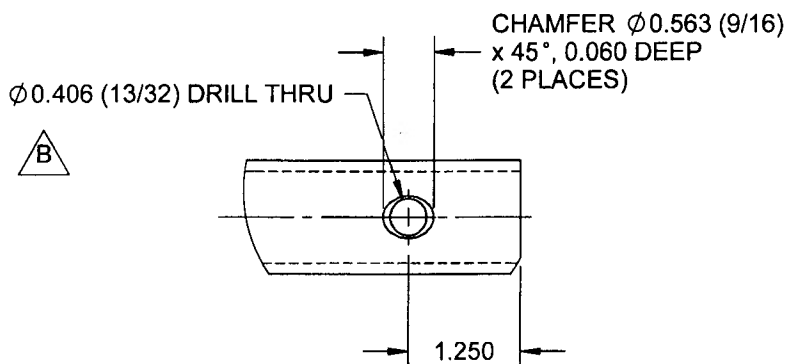
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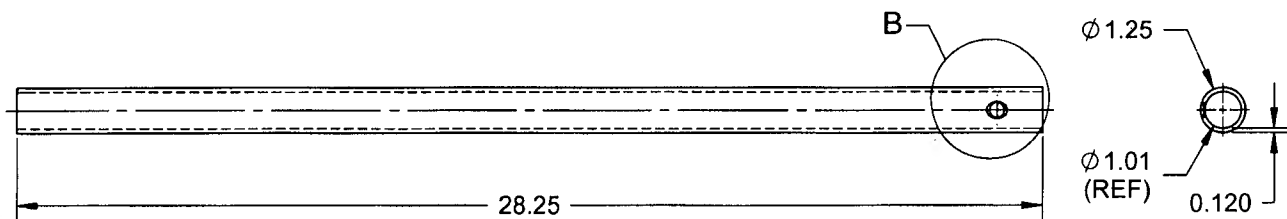
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:5



**DETAIL B  
SCALE 1 : 2**



**D3355-5 MEDIUM TUBING**

**NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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